



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9588	35/60/90
2	Machined By		V.T.L. N/A Shop	Drg. No. 1-S.D. 738
3	Pallet Die No.		10775 (G.O) N/A	Rev: 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	780 N/A Step OD 2 703 N/A	Tappet: 4
6	Inside Diameter	Drg. No.	600.12 N/A	Step length: 28 N/A
7	Width of Pellet Die	Drg. No.	221 N/A	
8	Grooves as per Drawing	Drg. No.	57x6x10 N/A 57x6x10 N/A	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		655 N/A	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		M16 2 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 24.7 N/A Tapping Depth: 28.8	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi: 28/7/13

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	6.5 N/A 7.10 N/A	6.5 N/A	All Lines	7.10 N/A	All Lines				Ravi: 28/7/13
3	External Relief Depth			55 N/A		30 N/A				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Ravi
6	Material Sent For Hardening On Date									Lark furnace

Inspected By (Sign) & Date

Ravi: 28/7/13

Reviewed by (Engineer-CNC)

Manager-QA